

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81645

81645

Page 2

Friday, March 16, 2012 12:59:32 PM

Item ID: D3304-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Tube Assembly
 Start Date: 3/29/2012 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 3/29/2012 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SA 1213128						
140 *140* Small Fab Small Fab	Small Fab Memo Debur	0.00 0.00							FF 12-05-02
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	Salster						

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Quality Control

Dart Aerospace Ltd

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 Revision ID: Stop ***NS2***
 Item Name: Tube Assembly
 Start Date: 3/29/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 3/29/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
190									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:15	OVEN TEMPERATURE:							
	FINISH TIME: 11:45								
	8200F								
200	QC3- Inspect Part Finish	0.00							
200									
QC	Memo	0.00							
Quality Control									
210		0.00							
210									
Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Assemble lanyard and pip pin as per Dwg D3304								

2X ~~✓~~ 12/07/19
 2 ~~✓~~ 12/27/19
 2 ~~✓~~ 12-07-19

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 *220* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		DAS 16 9-83 17/01/12		(x2)			
230 *230* Packaging Packaging	Identify as per dwg & Stock Location 5186 Memo	0.00 0.00				2x			SD 12-7-24
240 *240* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/7/24 ME 12-07-24

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NOTE: Date & initial all entries

Picklist Print

Page 1

Friday, March 16, 2012 12:59:36 PM

Work Order ID: 81645

81645

Parent Item: D3304-041

D3304-041

Parent Item Name: Tube Assembly

Start Date: 3/29/2012

Required Date: 3/29/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: C04.11.17Step 13 revisedKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

CBL-1240		Purchased	No			100	f	562.7006	1.0417	2.0834			
----------	--	-----------	----	--	--	-----	---	----------	--------	--------	--	--	--

CBL-1240

Cable

**

② FF 12-07-19

Location

Loc Qty

Loc Code

GA

562.700589

113565

3.911789

119021

477.922

119690

80.8668

2.0834

M304TR0.875W.065

Purchased

No

160

f

10.0000

1.3437

2.828842

M304TR0 875W 065

304 round tube .875 x .065w

**

Location

Loc Qty

Loc Code

MAT017

10

110680

10

3.0

12-3-28

BLBS-0016

Purchased

No

210

Each

11.0000

1

2

RI RS-0016

PIP PIN

**

② FF 12-07-19

Location

Loc Qty

Loc Code

ST283

11

113489

1

113565

10

2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 2

Friday, March 16, 2012 12:59:36 PM

Work Order ID: 81645

81645

Parent Item: D3304-041

D3304-041

Parent Item Name: Tube Assembly

Start Date: 3/29/2012

Required Date: 3/29/2012

Start Qty: 2.00

Required Qty: 2.00

CBL-460

Purchased

No

210

Each

425.0000

2

4

CBL-460

Loop Sleeve

**

(2) FF 12-07-19

Location

Loc Qty

Loc Code

GA

121574

425

4

117947

4

118140

33

119021

188

120809

200

D3304-5

Manufactured

No

210

Each

21.0000

1

2

D3304-5

Bracket

**

BL 12-7-18

Location

Loc Qty

Loc Code

WA022

21

54570

21

2

Friday, March 16, 2012 12:59:37 PM

Shop Packet Print

Page 2

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Dart Aerospace Ltd

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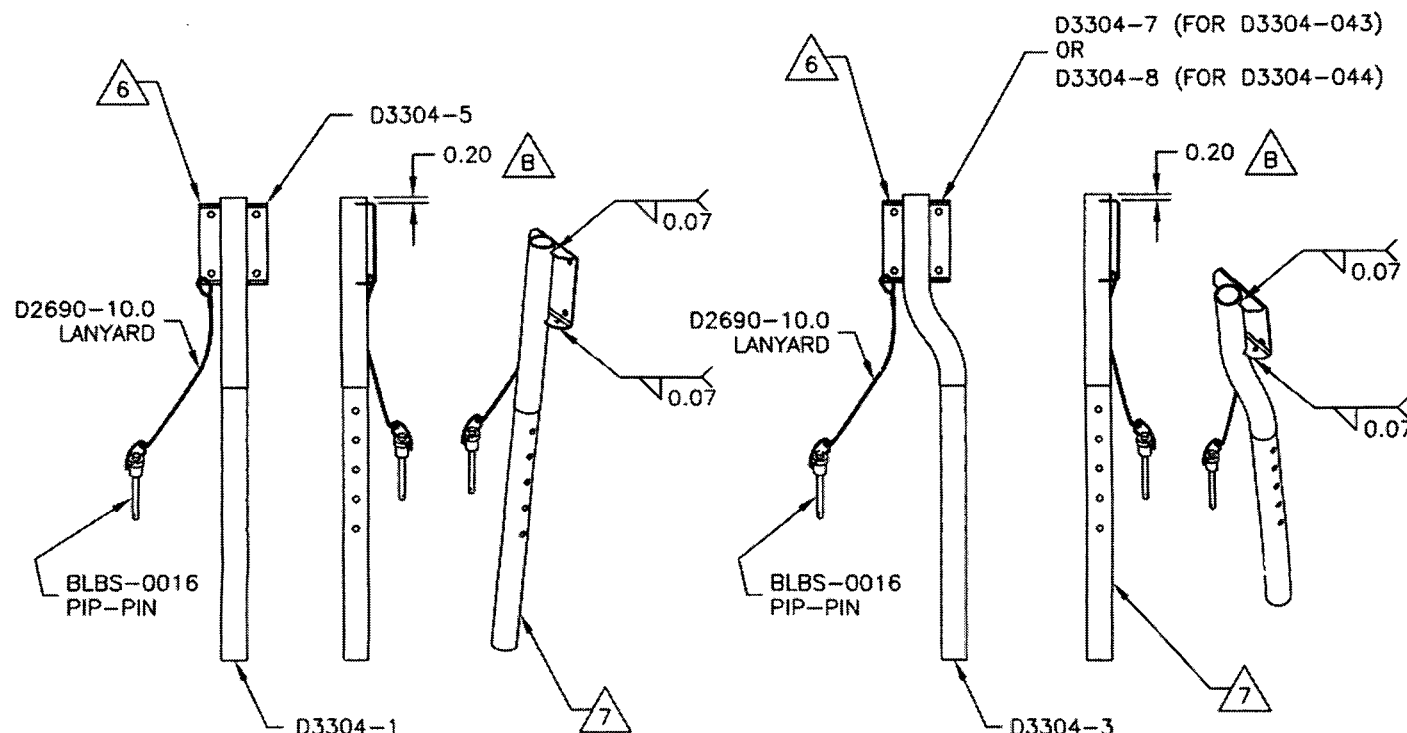
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



DESIGN	RF	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.07.15	TITLE	D3304	REV. B
			TUBE ASSEMBLY	SHEET 1 OF 4
				SCALE 1:6
A	04.08.18	NEW ISSUE		
B	05.07.15	UPDATE DIMENSIONS; ADD D3304-7/-8		



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81645 RD12-03-16

D3304-041/-043/-044 NOTES:

- 1) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER "TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"
- 7) IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

RELEASED
05.08.11

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

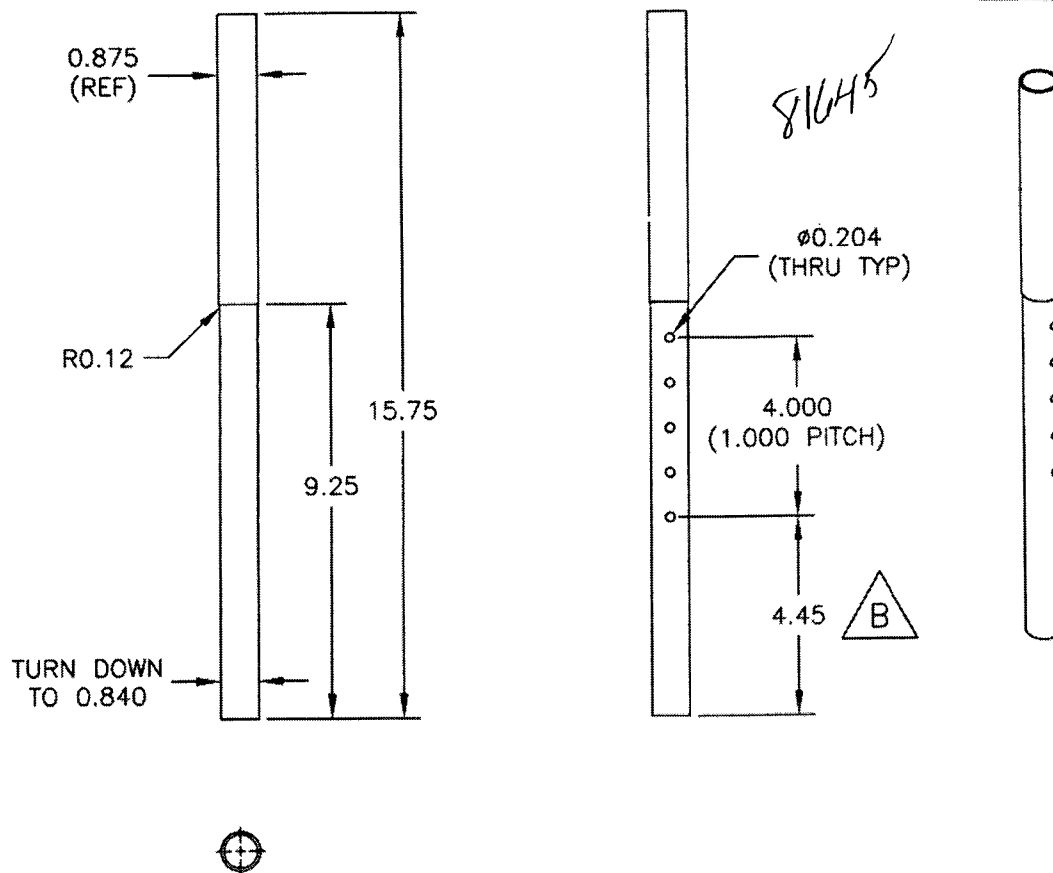
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NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. B SHEET 2 OF 4
DATE 05.07.15	TITLE TUBE ASSEMBLY		SCALE 1:4

RELEASED
05-08-11 *[Signature]***D3304-1 TUBE****D3304-1 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL
(REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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Dart Aerospace Ltd

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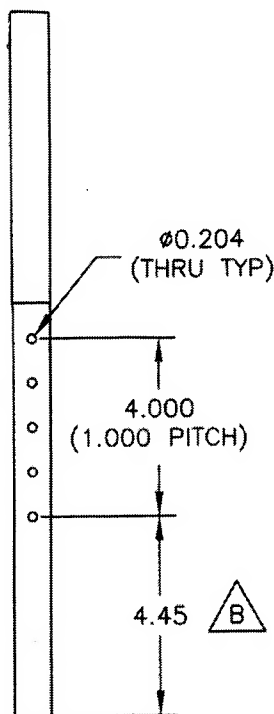
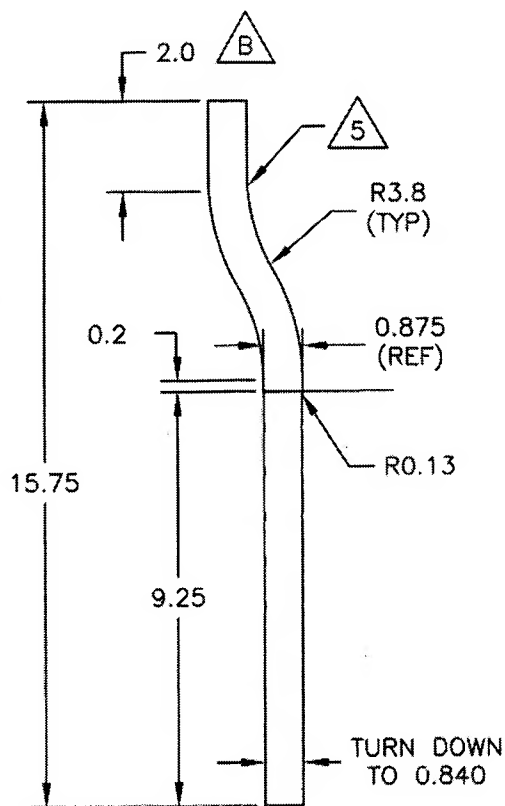
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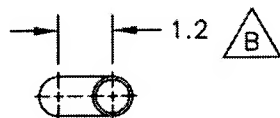
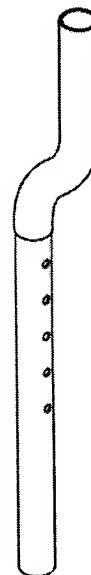
NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. B SHEET 3 OF 4
DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4



RELEASED
05-08-11



D3304-3 TUBE

D3304-3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.875 x 0.065 WALL
(REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) BEND LINES 9.625, 13.375 DIMENSIONS

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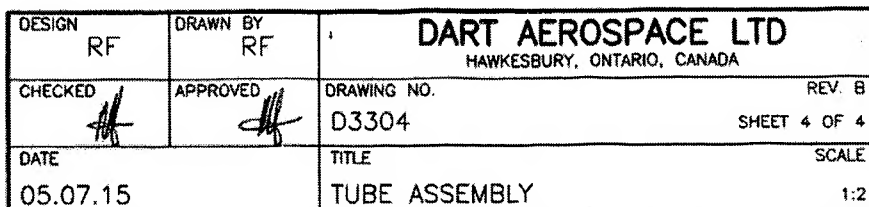
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RELEASE
05.08.11



Technical drawing of a U-shaped profile. The drawing shows a cross-section of the profile with the following dimensions: a radius of R0.094 for the inner corner, a height of 0.65, and a width of 2.750.

D3304-5/-7 BRACKET
D3304-8 OPPOSITE

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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